Work Order ID 62219

Thursday, September 30, 2010 9:00:47 AM

Item ID: D3404-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: GHW Lug

Start Date: 9/23/2010 **Start Qty:** 50.00 **Cust Item ID:**

Required Date: 10/13/2010 **Req'd Qty:** 50.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 10-9-30 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D3404 / Rev C									
100	BAND SAW	0.00							
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blank: 2.750" long	JL 10/10/25				(50)			
110	HAAS CNC VERTICAL MACHINING #1	0.00				50	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA555 and Dwg D3404 ☐Dwg Rev: C Folio Rev: AA ☐2-Deburr	SL/AL 10/11/02							
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				50	0		
Quality Control		SL/AL 10/11/02							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62219

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Start Date: 9/23/2010 **Start Qty:** 50.00 **Cust Item ID:**

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	B.A 10/11/02			50	ø		
QC	**Memo**	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: FORICL	0.00							
Packaging	**Memo**	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/11/02 (50)

CR 10/11/03

MF 10-11-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 30, 2010 9:00:47 AM

Work Order ID: 62219

Parent Item: D3404-1

Parent Item Name: GHW Lug

Start Date: 9/23/2010 **Required Date:** 10/13/2010

Start Qty: 50.00 **Required Qty:** 50.00

Comments: IPP Rev:A□05.09.01□New issue□KJ/JLM□
IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500 304 BAR .750 X 2.50		Purchased	No			100	f	0.0000	0.2291	12.05789			

JL 10/16/25

M15869

12.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62219
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	Ø.512	✓		Vern	ML-7
R0.65	+/-0.030	R.657	✓		"	"
0.125	+/-0.010	.130	✓		"	"
0.500	+/-0.010	.501	✓		"	"
2.14	+/-0.030	2.146	✓		Height gage	31006
1.30	+/-0.030	1.301	✓		Vern	ML-7
R2.30	+/-0.030	R.230	✓		N/A	~~[illegible]~~ N/A
1.14	+/-0.030	1.143	✓		Vern	ML-7
2.58	+/-0.030	2.583	✓		"	"

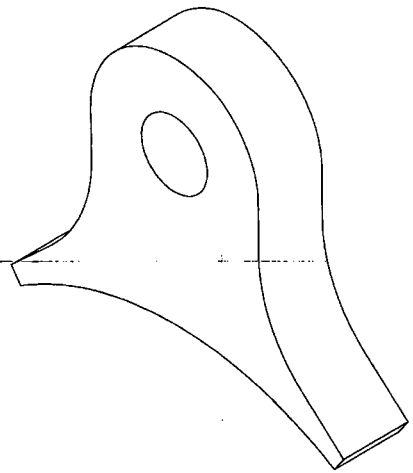
Measured by:	[signature]
Date:	10/11/02

Audited by:	S.A
Date:	10/11/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.12	New Issue	KJ/JLM	
B	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	

#62219



D3404-1 GHW LUG

RELEASED 08/12/18 MW

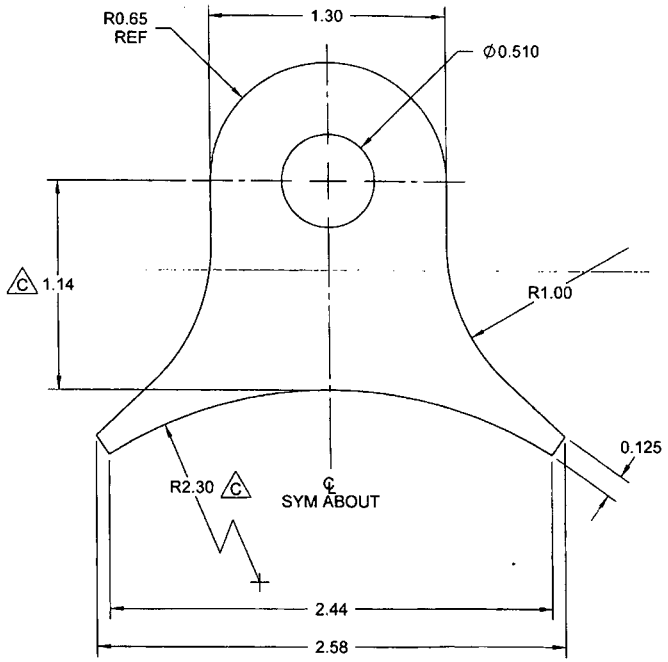
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

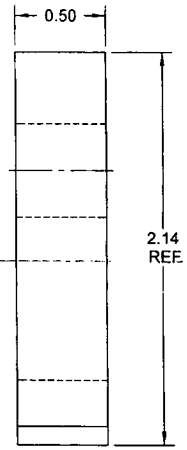
REV.	DESCRIPTION	BY	DATE
C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3404	REV. C
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE GHW LUG	SCALE NTS
DE APPR.			
DATE	08.12.02		

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#62219





RELEASED
08/12/18

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3404 REV. C SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE GHW LUG SCALE NTS
DE APPR.		
DATE	08.12.02	

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